

WORK ORDER 2007-22

Date opened: 23 July 2007

Project: Quick Release Cargo Basket Assembly
Type: Bell MediumBatch Quantity: 1 Complete Basket Assemblies (75110-01)
1 Forward Mounting Beam Assembly (75115-01)
1 Aft Mounting Beam Assembly (75116-01)Approval: Prototype (SH07-56)
Drawing List: DCL751-2, DCL751-3

Fabrication and Assembly Drawing(s)	Description
75110, Rev. 0	Basket Ass'y
75111, Rev. 0	Basket Body Ass'y
75112, Rev. 0	Basket Lid Ass'y
36255, Rev. 1	Handle Installation
36261, Rev. 1	Handle Bar Ass'y
36262, Rev. 1	Handle Bracket Ass'y
75115, Rev. 0	Forward Beam Ass'y
75116, Rev. 0	Aft Beam Ass'y
75132, Rev. 0	Tube Ass'y

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: _____

Inspector Signature: Jan 4/08
Date: _____

Drawing: 75110 Revision 0
 Assembly: 75110-01 Cargo Basket Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	75110-01	Cargo Basket Assembly			
1	75111-01	Basket Body Assembly	Below		
1	75112-01	Basket Lid Assembly	Below		
1	36255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace	7005	
1	MS20001P4	Piano Hinge		6067	
1	75127-01	Placard	0.063 Sheet, 6061-T6 Aluminum	960708	
3	49205-14	Bumper	Argus Industries Bumper	6038	
A/R	CR3213-4-02	Cherry Rivet		7010	
4	40088-14	Fitting	Ancra	6058	
4	AN960-616	Washer		6016	
1	AN3-15A	Bolt		6016	
1	AN3-17A	Bolt		6066	
4	AN960-10	Washer		6043	
2	AN970-3	Washer		5026	
2	MS21044N3	Nut		6016	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR3213-4-02 Rivets		<i>JH Clark</i>
Final Inspection	Drawing 75110			<i>JH Clark</i>

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 75111 Revision 0
 Assembly: 75111-01 Basket Body Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	75111-01	Basket Body Assembly			
2	75121-01	End Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	6026	
3	49210-02	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	6026	
2	75124-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
2	69825-01	Spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	6026	
2	75125-01	Spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	6026	
2	69826-01	Strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	6026	
1	36262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod	951108	
A/R	3/4-16F	Mesh	Expanded carbon steel	7029	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 75111			
Final Inspection	Drawing 75111			

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Drawing: 75112 Revision 0
 Assembly: 75112-01 Basket Lid Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	75112-01	Basket Lid Assembly			
2	75124-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
3	49213-01	Lid Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
1	49216-01	Spacer	1018 Steel, 1/2" Rod	951108	
1	36262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	9516042	
A/R	3/4-16F	Mesh	Expanded carbon steel	7029	
4	75128-01	Step Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
4	75128-02	Step Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	6026	
A/R	75112-11	Tread Plate	3003 Aluminum, 0.063 tread sheet	7058	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 75112			
Final Inspection	Drawing 75112			

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Drawing: 36255 Revision 1
Assembly: 36255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36255-01	Handle Installation			
1	36261-01	Handle Bar Assembly	Below		
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	7004	
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	6068	
2	AN3-14A	Bolt		6071	
4	AN960-10	Washer		6043	
2	MS21044N3	Nut		6016	

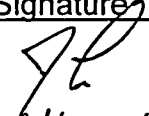

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 36255			<i>JH Clarke</i>

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Drawing: 36261 Revision 1
Assembly: 36261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	6006	
2	36271-01	Lever	304 Stainless, 0.105 Sheet	7006	
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	2005	
2	MS20615-4M3	Rivet		7039	

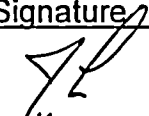

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36261			

Tag incomplete parts with Work Order # when stored between processes.

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Drawing: 36262 Revision 1
Assembly: 36262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	36261-01	Handle Bracket Assembly			
1	36272-01	Basket Bracket	321 Stainless, 0.050 Sheet	3021	
2	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	3021	
2	36275-02	Support	304 Stainless, 5/16" Rod	6003	


Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 36262			

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Drawing: 75115 Revision 0
Assembly: 75115-01 Forward Beam Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	75115-01	Forward Beam Assembly			
1	75130-01	Forward Beam	6061-T6 Al, 3/4 x 6 Bar		
1	75132-01	Tube	Below		
1	69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	6061	
1	69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	3005	
1	69830-23	Spring	15mm x 70 mm Spring	6063	
1	#10-32	Screw	Stainless steel, commercial	6069	
1	MS21044C3	Nut		1016	
2	AN5-4A	Bolt		7044	
2	AN960-516	Washer		7044	


Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 75115			

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Drawing: 75116 Revision 0
Assembly: 75116-01 Aft Beam Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
1 Total	75116-01	Forward Beam Assembly			
1	75131-01	Aft Beam	6061-T6 Al, 3/4 x 6 Bar		
1	75132-01	Tube	Below		
1	69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	6061	
1	69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	3005	
1	69830-23	Spring	15mm x 70 mm Spring	6063	
1	#10-32	Screw	Stainless steel, commercial	6069	
1	MS21044C3	Nut		1016	
2	AN5-4A	Bolt		7044	
2	AN960-516	Washer		7044	

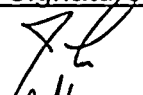

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 75116			

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Drawing: 75132 Revision 0
Assembly: 75132-01 Tube Assembly

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
2 Total	75132-01	Tube Assembly			
1	75132-02	Tube	304 Stainless Steel, 1x2x0.125	7006	
1	69830-07	Block	304 Stainless, 1/4" Sqr. Rod	7016	
2	69830-19	Cap	321 Stainless 0.025 Sheet	3021	
1	69830-11	Guide	304 Stainless 0.75 x 0.065 Tube	6049	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 70403			

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GUARDIAN

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Quick Release Cargo Basket Part #: 75110-01
Approval #: SH07-56 Serial #: 75101-01
WO #: 2007-022 Quantity: 1
Eligibility: Bell 205A-1 / 212 / 412 Work Status: Manufactured
Remarks: _____

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

Jan 4/08
Date

Jeff Clark
Inspector's Signature

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Forward Beam Assembly Part #: 75115-01
Approval #: SH07-56 Serial #: --
WO #: 2007-22 Quantity: 1
Eligibility: Bell 205A-1 / 212 / 412 Work Status: Manufactured
Remarks: _____

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

Jan 4/08
Date

Jeff Clark
Inspector's Signature

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: Aft Beam Assembly Part #: 75116-01
Approval #: SH07-56 Serial #: --
WO #: 2007-22 Quantity: 1
Eligibility: Bell 205A-1 / 212 / 412 Work Status: Manufactured
Remarks: _____

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

Jan 4/08
Date

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